

Date: Thursday, 6/21/2007 2:28:57 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT					
Job Number	: 33052		Part Number	: D2565111					
Estimate Number	: 10285		Drawing Number	: D2565 REV E					
P.O. Number	: N/A		Project Number	: N/A					
This Issue	: 6/21/2007	S.O. No.	: N/A		Drawing Revision	: E			
Prsht Rev.	: NC		Type	: SMALL /MED FAB		Material	: N/A		
First Issue	: N/A		Due Date	: 7/5/2007		Qty:	6	Um:	Each
Previous Run	: 32464		Comment	: Est: E 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC Est: E 06.05.03 Change level 2/8 to QC5					
Written By	:		Type	: EC					
Checked & Approved By	:								
Comment									

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W 
Comment: Qty.: 1.1944 f(s)/Unit Total : 7.1663 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)		Batch No: M104862  FF 07-07-09 6
2.0	BRAKE NC	NC BRAKE 
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313		FF 07-07-09 6
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr and polish		SAD 07/07/09 6
4.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		Sc 07/07/09 6
5.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3		m 101575  BL 07-07-10 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07107123  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 33052

Part Number: D2565111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*P7/1/16*

*(6)*

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST207

*ST207*

*P7/1/16 (6)*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07.07.16 HJ*

Job Completion



*u 07.07.16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

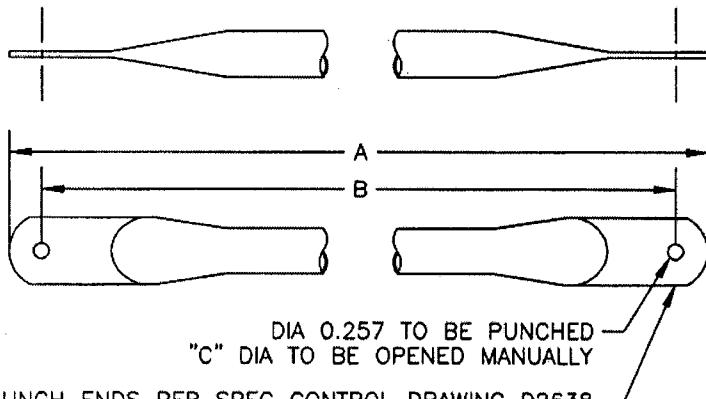
NOTE: Date & initial all entries



COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	SHEET 1 OF 1
		D2565		
DATE		TITLE	SCALE	
04.05.05		STRUT		1:3

RELEASED  
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF. DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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ENGINEERING

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WITHOUT NOTICE

WORK ORDER

NO. 33052

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